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INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 6 : C22C 29/08 — A1

(11) International Publication Number: **WO 99/13119**

(43) International Publication Date: 18 March 1999 (18.03.99)

(21) International Application Number: PCT/SE98/01572

(22) International Filing Date: 4 September 1998 (04.09.98)

(30) Priority Data:
9703202-3 5 September 1997 (05.09.97) SE

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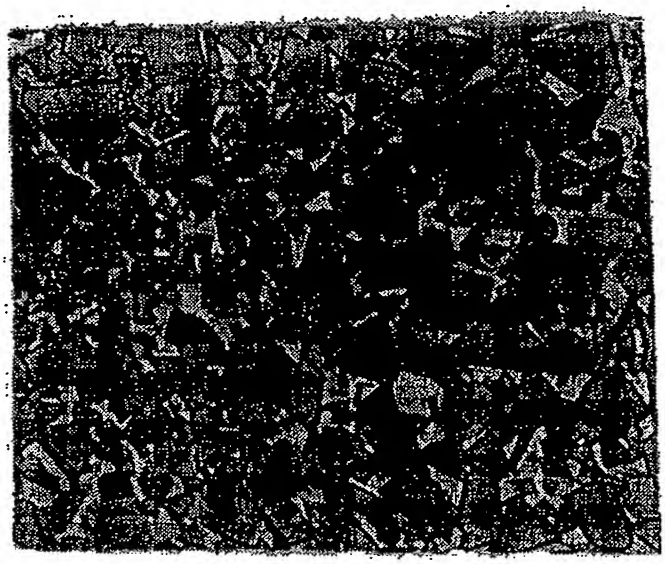
(81) Designated States: CN, JP, KR, RU, US, European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE).

Published
With international search report.

(54) Title: CORROSION RESISTANT CEMENTED CARBIDE

(57) Abstract

The present invention relates to a corrosion and oxidation resistant cemented carbide containing WC and 6–15 wt.% binder phase whereby the binder phase contains 8–12 wt.% Cr+Mo with an average WC grain size of 3–10 μm. This is obtained by selecting a total carbon content in the interval of 6.13–(0.05±0.007) x binder phase content (wt.%).



Corrosion resistant cemented carbide

The present invention relates to corrosion resistant cemented carbide. By using a carefully controlled manufacturing process a cemented carbide with corrosion resistant binder phase and coarse carbide grains has been obtained.

Cemented carbide for corrosion resistance demanding applications such as seal rings, bearings, bushings, hot rolls, etc. generally has a binder phase consisting of Co, Ni, Cr and Mo where the Cr and/or Mo addition acts as corrosion inhibiting additions. An example of such a cemented carbide is disclosed in EP 28 620. A disadvantage with the Cr and/or Mo additions is that they, particularly Cr, also act as grain growth inhibitors which means that it is not possible to make corrosion resistant cemented carbide with a coarse grain size. The above mentioned EP 28620 discloses a WC grain size <2 µm.

Fig 1 shows the microstructure in 1700X magnification of a cemented carbide according to the invention.

Fig 2 shows the microstructure in 1700X magnification of a cemented carbide with the same composition but sintered according to prior art.

It has now surprisingly been found that if the binder phase is saturated with respect to carbon then the grain growth inhibiting effect of Cr and/or Mo is inactivated and grain growth during sintering takes place. As a result corrosion resistant cemented carbide with coarse WC grain size is obtained. The average WC grain size shall be 3-10 µm, preferably 4-8 µm, most preferably about 5 µm. The cemented carbide according to the invention shall preferably be free of graphite. However, a certain graphite porosity <C02 can be accepted in the interior of the body, but in the surface region,

tering shall take place at a temperature in the higher end of the allowed temperature range. For the binder phase contents according to the invention a temperature in excess of 1550 °C is suitable. Cooling from sintering temperature shall be made as quickly as possible generally at a speed in excess of 15 °C/min down to 1100 °C.

The material according to the invention is particularly useful for seal ring applications in pumps used in fresh water or sea water with demands on high pV-values. Typical working conditions for the pump are a working pressure exceeding 0.5 Mpa with a running speed of 2500 rpm.

Example 1

Cemented carbide for seal rings were made with the composition of 91% WC, 8% Ni, 0.7% Cr and 0.3% Mo. Half of the rings was according to the invention sintered at 1570°C and cooled from sintering temperature with a speed of 13°C/min. To the powder had been added additional carbon (soot) and as a result the rings had a carbon content of 5.70 wt-%. The resulting microstructure had an average WC grain size of 5 µm, as is evident from Fig 1. The other half was sintered at 1520°C according to prior art and had a carbon content of 5.64 wt-% after sintering and an average WC grain size of 1 µm, Fig 2.

Example 2

The cemented carbide rings from example 1 were tested according to a standardized test method with one stationary ring and one rotating ring of the same composition. The testing was performed in different corrosive media with different pressures acting on the rings. The results are based on three pairs of each ring type.

cooling atmosphere was hydrogen gas. To the powder had been added additional carbon (soot) and as a result the rings got a carbon content of 5.65 wt-%. The microstructure had a nice and even sintered structure with an average WC grain size of 5μm.

Corresponding seal rings according to prior art were manufactured with a carbon content of 5.52 wt-% Carbon and sintered at 1450 °C. The microstructure showed a nice and even sintered structure with an average WC grain size of 1.8 μm.

Three sets of seal rings from each iteration were manufactured. The OD of the rotating and stator ring was 175 mm. The ID was 150 mm. The seal surface had a width of 3 mm. Field testing was performed with six propeller pumps, with a 60 kW motor plus accessories. The depth was 30 m in sea water. Service of the pumps was performed after 2100 hours running time. The inspection showed that all seal ring packages with the cemented carbide material according to prior art had thermal cracks in the seal surface. One of the seal ring packages had caused leakage due to a crack through the seal ring. All ring packages according to prior art showed cracks that gave chipping (pop-ups) of the material from the seal surface. This phenomena is detrimental for the seal application and could lead to a catastrophic failure.

The seal rings according to the invention also show thermal cracks in the seal surface, but no chipping of the cemented carbide material could be observed from the seal surface.

The seal rings according to the prior art were scrapped and exchanged by other seal rings. The rings according to the invention were running another 2100 hours without any pre-treatment of the seal surfaces.

Claims

1. Corrosion and oxidation resistant cemented carbide containing WC and 6-15 wt-% binder phase whereby the binder phase contains 8-12 wt-% Cr+Mo c h a r a c t e r i s e d in that the average WC grain size is 3-10 µm and the total carbon content is in the interval of 6.13-(0.05±0.007) x binder phase (Co+Ni) content in wt-%.

2. Cemented carbide according to claim 1 c h a r a c t e r i s e d in that the average WC grain size is 4-8 µm.

3. Cemented carbide according to claim 1 c h a r a c t e r i s e d in that the average WC grain size is about 5 µm.

4. Cemented carbide according to any of the preceding claims c h a r a c t e r i s e d in that the content of binder phase is 8-11 wt-%.

5. Cemented carbide according to any of claims 1-3 c h a r a c t e r i s e d in that the content of Ni+Co-binder phase is about 10 wt-% with a Co/Ni-ratio of 0.75-1.25.

6. Cemented carbide according to any of the preceding claims c h a r a c t e r i s e d in that Mo is not present in the binder phase.

7. Method of making a corrosion and oxidation resistant cemented carbide containing WC and 6-15 wt-% binder phase whereby the binder phase contains 6-11 wt-% Cr+Mo by milling powders forming the hard constituents and powders forming the binder phase, drying, pressing of the powder mixture to bodies of desired shape and sintered c h a r a c t e r i s e d in that the powder mixture has such a carbon content to give a carbon content of the sintered body of 6.13-(0.05±0.007) x binder phase content (wt-%).

Fig. 1

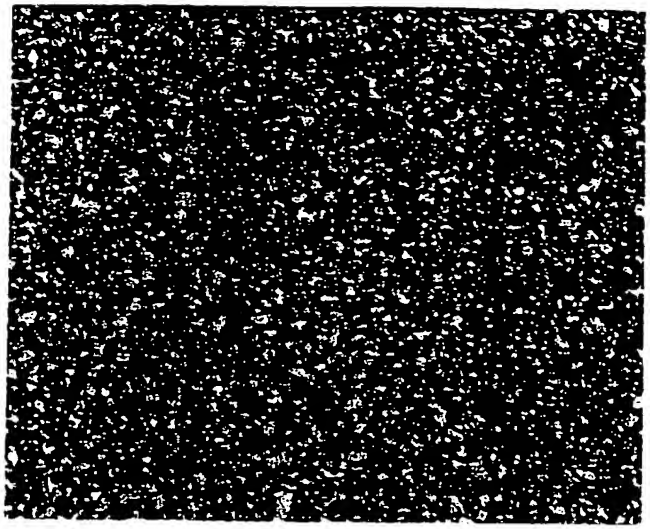


Fig. 2

INTERNATIONAL SEARCH REPORT

International application No.
PCT/SE 98/01572

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 4497660 A (LEIF LINDHOLM), 5 February 1985 (05.02.85), column 3, line 15 - column 6, line 56	7-9
A		1-6

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